

Shipping Monday

Dart Aerospace Ltd.

Date: Wednesday, 6/7/2006 9:14:04 AM
User: Linda Lacelle

Process Sheet

19/06

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT STEP ASSEMBLY HIGH SKID LH
Job Number	: 27432		
Estimate Number	: 10575		
P.O. Number	: N/A	Part Number	: D350591213
This Issue	: 6/7/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3078 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26419	Drawing Revision	: A
		Material	: N/A
		Due Date	: 6/14/2006
Written By	: <u>See Comment Below</u>	Qty:	12 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:B 05.10.14 Modified step 10 KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-213 CHG001

chg 002

KS 06.06.07

(12)

2.0	D2622120C	Extrusion
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2622-120C Extrusion 327077

SE 06.06.07

12

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

SE 06.06.07

12

SE 06.06.07

12

SE 06.06.08

12

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

2066.06 (12)

5.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/06/19

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 9:14:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 27432

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3067-1

End Plate B26411

PE 06.06.08

12

6.0

D30631

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3063-1

Support

B24353

PE 06.06.08

12

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072

A/R Aluminum Rod M15689
M19173

3-Grind End Plate flush

PE 06.06.08

PE 06.06.08

PE 06.06.08

12

12

12

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 9

06.06.09

SA 06/06/09

(12)

12

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN

06.06.08

(12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL

06/06/10

(12)

11.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B26211

06/06 / 12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 9:14:04 AM
User: Linda Lacelle

Process Sheet

Shipping Monday 19/06

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 27432

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

$326258 = 22$
 $327526 = 2$

h.e. 06.06.12

13.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

$m19085 = 208$

h.e. 06.06.12

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

h.e. 06.06.13

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-06-13

16.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

326411

h.e. 06.06.13

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod $m15689$

h.e. 06.06.13

h.e. 06.06.13

h.e. 06.06.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 9:14:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 27432

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Grind End Plate flush

FF 06-06-13 (6) / PE 06-06-13 = 6

18.0

QC5/9

WELD INSPECTION



Comment: Inspect work & Weld to Current - Check dimension as per Dwg

PD 06-06-15
7 06-26-15

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

H.M 06-06-15

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-06-15

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

a.m 06-06-15

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

PUC/1 16 (12)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D2182B035

Rubber Cushion



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

2 D2182b035 Rubber Cushion

B24870

25.0

D2274

Radius Block



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

4 D2274 Radius Block

B26078

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 9:14:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 27432

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2732030

Rubber Cushion



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2732-030 Rubber Cushion B26472 ✓

27.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 7.2000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip B26041 6mcp ✓

B25656 6mcp ✓ B2856 600 ✓

28.0

D30641

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3064-1 Clamp B23406 14mcp ✓ B26667 10mcp ✓

29.0

D30801

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3080-1 Clamp B25453 ✓

30.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M19551 ✓

31.0

AN411A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A Bolt M17771 ✓

Date: Wednesday, 6/7/2006 9:14:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 27432

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer 100743 ✓

33.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 144.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M100525 ✓

34.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M10393 ✓

35.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4 Nut (or -4) M19085 ✓

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location:

PPP Rev:

B

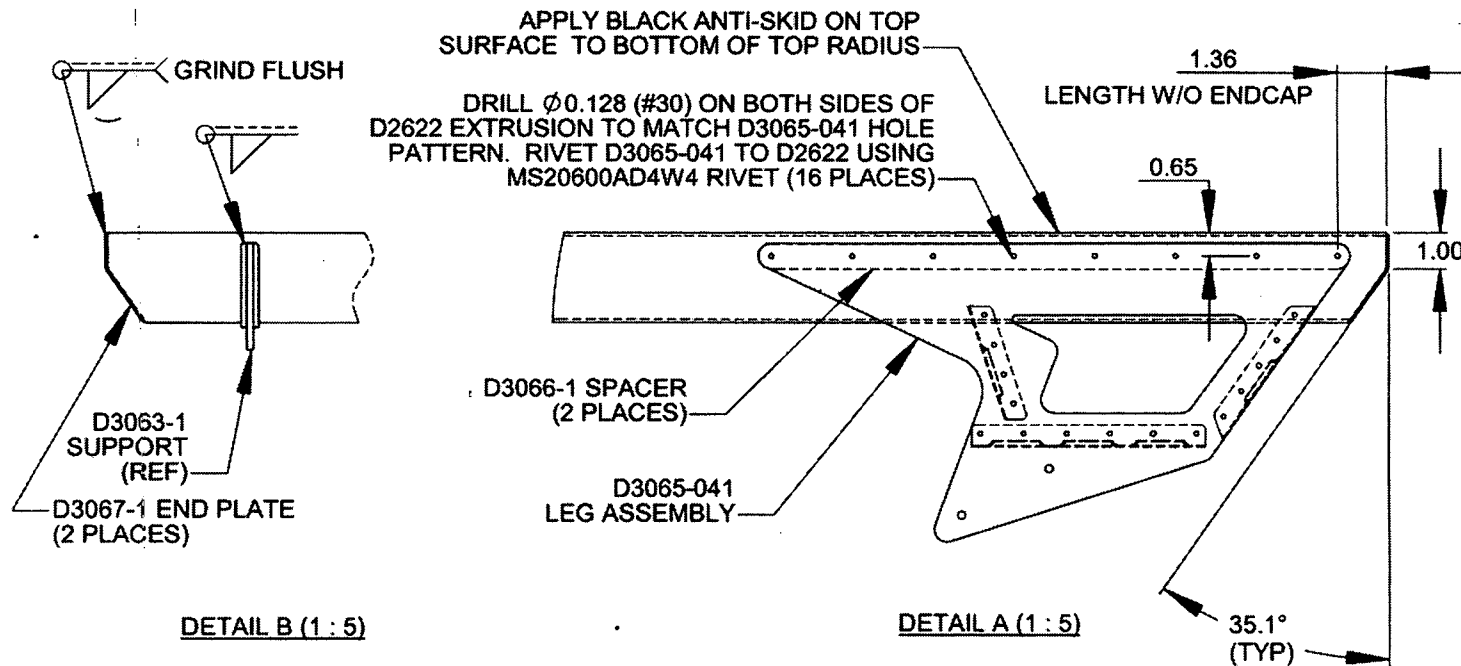
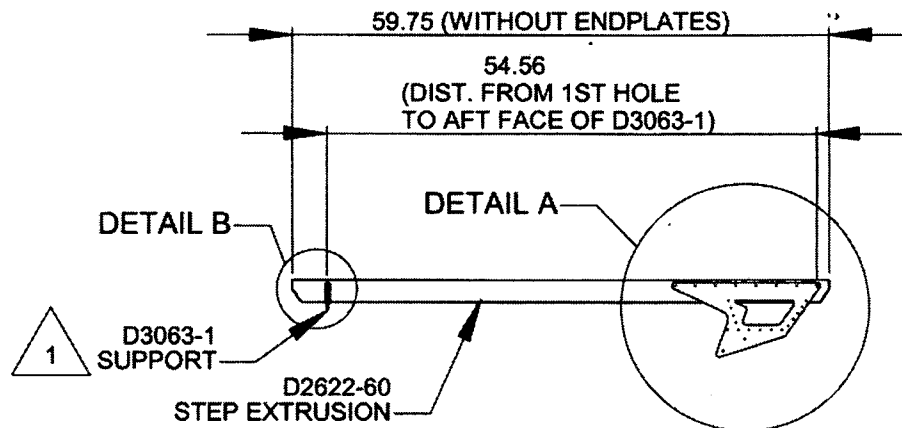
6/6/16 (12)

DART



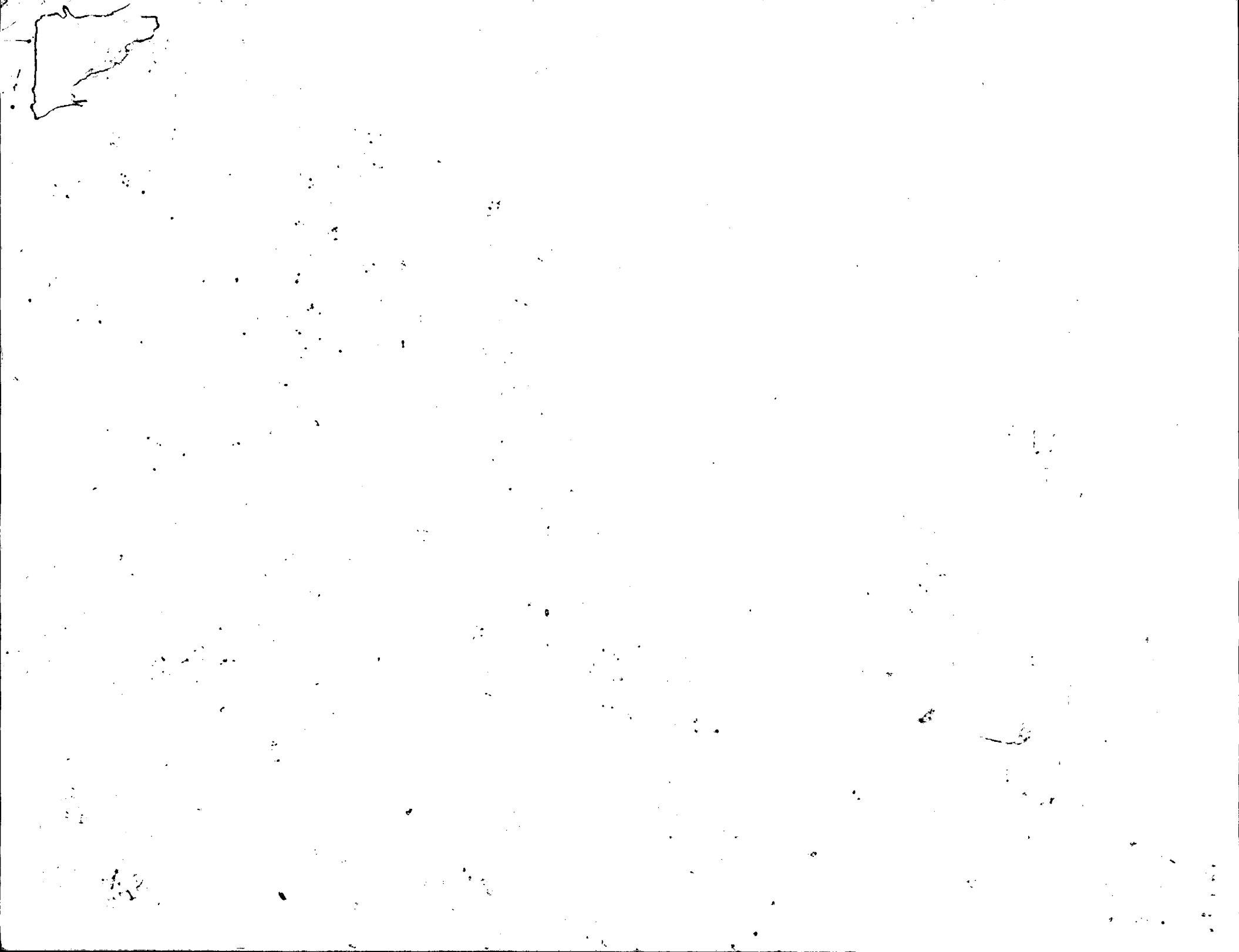
DESIGN	SP	DRAWN BY	SP	DART AEROSPACE LTD
CHECKED	SP	APPROVED	SP	HAWKESBURY, ONTARIO, CANADA
DATE	02.09.11	DRAWING NO.	D3078	REV. A
		TITLE	STEP ASSEMBLY, HI SHORT	SHEET 2 OF 2
		SCALE	1:20	

RELEASED
02.09.2004



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Date: Friday, 6/23/2006 3:02:21 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D350-591-211/-212/-213/-214/-215/-216
 Job Number : 27682
 Estimate Number : 10804
 P.O. Number : NIA Part Number : Z_CUSTOM
 This Issue : 6/23/2006 S.O. No. : NIA Drawing Number : ADD PARTS & PAPERWORK
 Prsht Rev. : NC Project Number : NIA
 First Issue : 6/23/2006 Type : NIA Drawing Revision : NIA
 Previous Run : 00015 Material : NIA
 Written By : SEE ABOVE USER & DATE Due Date : 6/30/2006 Qty: 24 Um: Each
 Checked & Approved By :
 Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DSI9340011 STEP MOD KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)
 STEP MOD KIT

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD TO KITS IN STOCK

1 X DSI 9340-011 B 27681

STOCK AFFECTED:

D350-591-211 (4 X B18906) 4/1 A

D350-591-212 (0)

D350-591-213 (6 X B27432) 25

D350-591-214 (7 X B26656 / 2 X B25434) OK

D350-591-215 (2 X B26681) 71

D350-591-216 (2 X B25753 / 1 X B26732) OK

Remove: D2182 B035
 D3080-1
 D3064-1

Add new 12bels
 CHG 002 30/06
 22 new
 24/6/26 (22)

3.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP & RETURN TO STK

134 07
 234 02
 67 01
 8 X B18755
 1 X B23406
 4 X B 26667
 D3064-1

1683
 432.68
 Aa pac